DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 70.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-004836
Date Inspected: 25-Nov-2008

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Japan Steel Works

OSM Arrival Time: 2200
OSM Departure Time: 700
Location: Muroran, Japan

CWI Name: Makhmud Ashadi

Inspected CWI report:	☑ Yes	☐ No	☐ N/A	**CWI Present:**	☑ Yes ☐ No
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes ☐ No ☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes ☐ No ☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes ☐ No ☐ N/A
				Approved WPS:	☑ Yes ☐ No ☐ N/A
				Delayed / Cancelled:	☐ Yes ☑ No ☐ N/A

Bridge No: 34-0006
Component: Tower, Jacking and Deviation Saddles

Summary of Items Observed:

On this date, Caltrans Office of Structural Materials (OSM) Quality Assurance Inspector (QA) James Weaver was present at the Japan Steel Works (JSW) jobsite in Muroran, Japan for the purpose of observing in-process fabrication of components for the Tower, Jacking and Deviation Saddles. Current work: Casting, machining, welding and nondestructive testing of Saddles and Bases.

T1-2 Base

The QA inspector observed the in process welding of the structural steel plates for the Tower Saddle Base T1-2. The JSW welding personnel S. Watananbe, ID 08-5159 continued the fill welding of joint 8Y-5V (2-3) in the flat position. K. Yashihito. , ID 08-5158 continued the fill welding of joint 8Y-12V (2-3) in the flat position. The welding was performed utilizing the gas shielded flux cored arc welding process per the welding procedure specification (WPS) SJ-3012-3. Intertek Testing Services Quality Control (QC) inspector Mr. Makhmud Ashadi monitored the welding parameters and heat control at periodic intervals. The minimum preheat temperature of 110°Celsius and maximum interpass temperature of 260° Celsius were verified to meet the WPS requirements by Mr. Ashadi and the QA inspector utilizing Tempilstik temperature indicators. This data was entered into the QC inspector's daily log, identifying the location on a weld map. The work was not completed on this date and appears to meet the minimum requirements of the welding procedure specification and contract documents.

Summary of Conversations:

There were general conversations with Intertek Testing Services Certified Welding Inspector Mr. Makhmud Ashadi relative to the location of the welding and inspection personnel in the fabrication shop number 4.

Comments

WELDING INSPECTION REPORT

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	Weaver,James	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer